

Work Order ID 70687

Monday, June 13, 2011 1:32:22 PM

Page 1

Item ID: D3537-1

Accept

Revision ID:

Item Name: Wearpad

Start Date: 6/13/2011 Start Qty: 50.00

Required Date: 6/17/2011 Req'd Qty: 50.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr if necessary

B11-6-15

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-15

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulx15

counts
(x60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70687

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Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

SB 11/6/20

(60)

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
M118453 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

EL 11-8-23 (42)

150

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8 Jul 05/23

counter (42)

W/O:		WORK ORDER CHANGES					
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Work Order ID 70687

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Item ID:	D3537-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearpad					
Start Date:	6/13/2011	Start Qty:	50.00		Cust Item ID:	
Required Date:	6/17/2011	Req'd Qty:	50.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

170	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 3:45								
	FINISH TIME: 4:15								

180	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

42x0 m-11/08/23

42 BR 11-8-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: *FP-16* 0.00



Packaging

Memo

0.00

Packaging

NA BR 11-8-24,

200

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/8/24 HJ

*11-08-23
42*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 1:32:28 PM

Page 1

Work Order ID: 70687

Parent Item: D3537-1

Parent Item Name: Wearpad




Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	119.1000	0.106	5.578947			



1311-6-15

Location

Loc Qty

Loc Code

MAT020

119.1

117275

4.3

117653

114.8

117653

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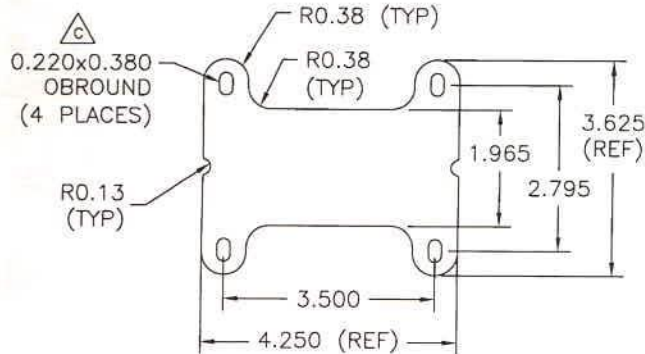
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

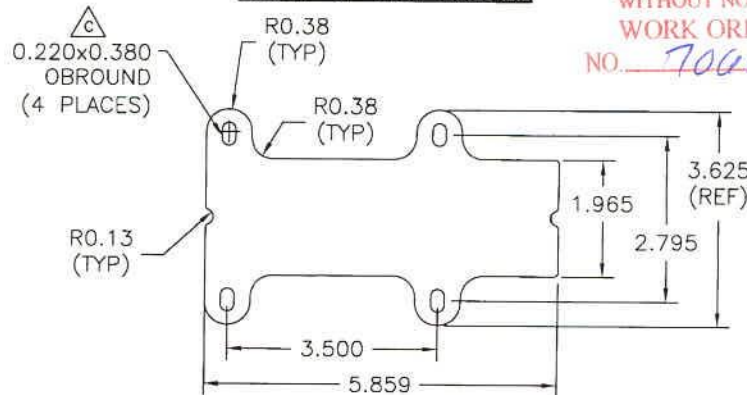
WITHOUT NOTICE
WORK ORDER

NO. 70087

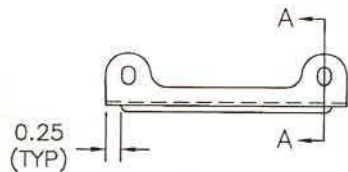
D3537-1F FLAT PATTERN



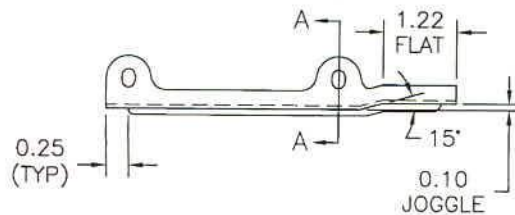
D3537-3F FLAT PATTERN



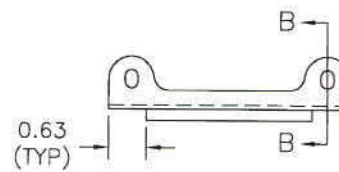
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



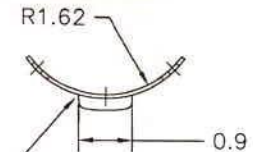
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

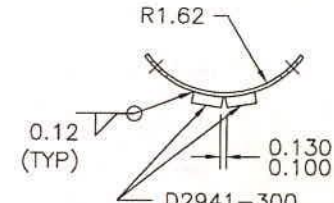


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

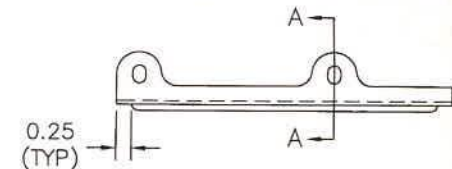
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.03 PM
per ELN
952

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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